

Work Order ID 54271

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December 7, 2009 12:54:54 PM

Item ID: D6103-003

Accept



Setup Start



Revision ID:

Item Name: Round Billet, Aluminum

Stop



Start Date: 12/07/09 Start Qty: 40.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 09/12/07 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D6103	Rev B

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10903 a) Description: Alluminum round billet b)
 $\varnothing 3.500"$ x 12.500" long c) Tolerance on all dimensions are +0.030"/-0.000"

 d) Material: 7075-T7351 (QQ-A-225/9) Material certification required

CL 09/12/07 40

110



Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

120



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Amk 09/12/09

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54271

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: MAT

0.00

*ark 09/12/29*44

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

AB 10.01.05

MF
09-12-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

December 7, 2009 12:54:53 PM

Work Order ID: 54271



Parent Item: D6103-003



Parent Item Name: Round Billet, Aluminum

Start Date: 12/07/09

Required Date: 12/18/09

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6103-003P 		Purchased		No		110	Each	0.0000	40.0000		<i>PC-9/14/10</i>	<i>94</i>

round alum billet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

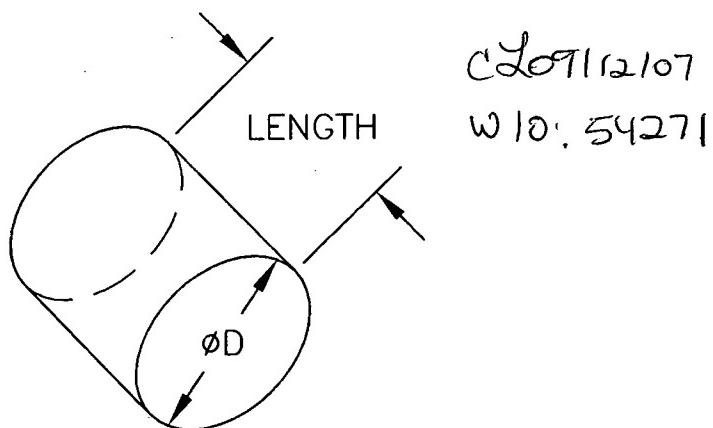
NOTE: Date & initial all entries



DESIGN <i>A1</i>	DRAWN BY <i>A1</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D6103	Rev. B SHEET 1 OF 1	
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS	
A	01.04.10	NEW ISSUE		
B	06.01.31	ADD D6103-003		

SPECIFICATION CONTROL DRAWING

RELEASED



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

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Castle Metals®

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Pack Slip No:9901305

Ship From:	Sold To:	Ship To:	Deliver To:		
Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		
Date Shipped	F.O.B.	Freight Terms	Carrier	BOL No	Delivery No
17-DEC-09	ORIGIN	Prepaid	MANITOULIN	159583-2	9901305

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No	Line No	Item No	Description			
448776	1	8808.MO	3.5000.RD.7075.T7351.ALUMINUM.CF.132.0000-144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 4124,AMS-QQ-A-225/9,ASTM B211			
Purchase Order No	Part Number		Ordered Qty	Invoice Qty	Backorder Qty	
10903			44 PCS	44 PCS		
Details						
Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty (LBS)
	20123374		44			533.52

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.						
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.						
This material has been received and inspected by:		Date:				

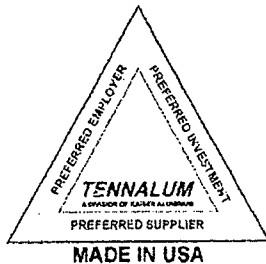
ank 09/12/29

KAISER

ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT

<http://Certs.KaiserAluminum.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES. Material complies with FAR BAA (FAR 52.225-1, Buy American Act-Supplies), DFARS BAA (DFARS 252.225-7001 Buy American Act & Bal of Payments Prog), and FAR TAA (FAR 52.225-5 Trade Agreements) AS9100B:2004 Material is RoHS compliant.

Castle Metals FP

HEAT NUMBER	20123374
MECHANICAL ID	
ITEM CODE	8803
LOT NUMBER	
PO NUMBER	17132
RECEIVED DATE	9-15-09
SUPPLIER	Kaiser
SPECIFICATION	
LCS	N
COMMENT	
APPROVED	BJ

JK 09/12/09

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

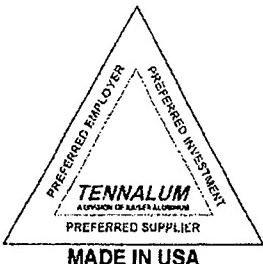
John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 125177

Kaiser Order Number: 653278

Line Item: 1



CERTIFIED TEST REPORT
<http://Certs.KaiserAluminum.com>

Tennalum
 PO Box 669
 Jackson, TN 38302
 731-423-2811

CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		PRODUCT DESCRIPTION:				
01-22172-1		17132		8808 Cold Finished Round				
KAI SER ORDER NUMBER:	LINE ITEM:	SHIP DATE:		ALLOY:	TEMPER:			
653278	1	09/08/2009		7075	T7351			
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:		DIAM/DAF/THKNS:	WIDTH:	LENGTH:		
1965 lbs.	14 pcs.	29771		3.500 in.	0.000 in.	144.0 in.		
SHIP TO:				SOLD TO:				
A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA				A M Castle & Co AM Castle & Co. 3400 No. Wolf Road Franklin Park, IL 60131 USA				

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG.			LONG.			COND
	UTS	YTS	ELONG.	%	%	IACS	
ksi	ksi						
20123374	71.9	60.0	16.0	39.2			

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
	Actual	0.08	0.24	1.6	0.02	2.7	0.19	6.0	0.02		20123374
Max		0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min				1.2		2.1	0.18	5.1			

Specifications

Standard: ISO 9001, ASTMB211-03, AMS4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

*John Rennekamp
09/12/29*

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 125177

Kaiser Order Number: 653278



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO10903**

Purchase Order Date 12/07/09
PO Print Date 12/07/09

Page Number 1 of 1

Order From :

VC-MET001

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - BOX B9204 PO BOX 9100
TORONTO, ON M4Y 3A5
CA

FAXED
FORWARDED

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6103-003P	round alum billet	12/18/09 Yes	40.00 Each	Yours ppd	\$65.0000	\$2,600.00
<i>acc 44 Pcg/12/10</i>							
Special Inst: AS PER DWG D6103 REV.B B54271 SIZE: 3.50" X 12.500" LONG TOLERANCE ON ALL DIMENSION ARE +0.030"/-0.000" MATERIAL: 7075-T7351 (QQ-A-225/9)							
PO Total:							\$2,600.00

**MATERIAL CERTIFICATION
REQD UPON DELIVERY**

CL
V
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 12/07/09